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Mixing table vacuum casting systems

Properties		Colour	Mixing ratio p.b.w.	Pot life min.	Mould temperature in °C	Curing time in min.	*Shore hardness	*Flexural modulus in Mpa	*Flexural strength in Mpa	*Flexural strength at breakage in %	*Impact resistance (Charpy) in kJ/m²	*Heat resistance HDT °C	*Glass transition temperature T _g °C
Hard systems			Processing				Physical data						
MG 703 / Z 400	high impact strength	white	100 : 31	8 – 12	40 – 60	40 – 45	D 77	1340	52	–	77	81	105
MG 707 / Z 400	middle E-modulus, HDT 107°C	white	100 : 30	8 – 12	40 – 60	40 – 45	D 79	1500	63	–	24	107	120
MG 804 A / B	high impact strength, very well castable, long pot life	white / black	100 : 100	10 – 13	60 – 70	45 – 60	D 78	2270	90	6,2	39	71	82
MG 804 A / MG 804-1 B			100 : 100	8 – 11	60 – 70	45 – 60	D 75	1975	80	6,3	31	82	87
MG 804 A / 804 GF A / MG 804-1 B	glassfibre filled, E-modulus variable	white / black	100 : 100 : 150	7 – 9	60 – 70	45 – 60	D 78	2600	78	4,9	17	89	90
MG 804 GF A / MG 804-1 B	glassfibre filled, very high E-modulus 4400 Mpa	white / black	100 : 50	7 – 9	60 – 70	45 – 60	D 80	4400	85	2,5	13	76	82
MG 815 A / B	high heat resistance, HDT 140°C, very high impact resistance	black	100 : 70	5 – 7	70	40 – 60	D 80	2100	100	8,6	75	130	122
MG 815-1 A / MG 815 B			100 : 70	5 – 7	70	40 – 60	D 80	2100	100	9	63	140	135
MG 815 A / MG 815 GF B	glassfibre filled, high rigidity	black	100 : 90	6 – 8	60 – 70	40 – 60	D 80	2510	87	7,8	22	–	122
MG 815 A / MG 815 FR B	flame retardant acc.to UL 94 V0,	black	100 : 120	5 – 7	70	40 – 60	D 83	2770	70	4,5	18	120	122
MG 807 FR A / B	flame retardant acc.to UL 94 V0, very high E-modulus	beige	100 : 100	6	40 – 70	35 – 45	D 85	4000	70	2,2	7,3	52	79
Semi-hard system													
MG 822 A / B	high impact resistance, high heat resistance, medium E-modulus, dyeable	transparent/black	100 : 45	7	70	60	D 72	1150	45	9,0	no break	120	n.a.

Flexible systems				Hours		Elongation %		Tear resistance		Tensile strength MPa		
GM 900-1 A / B	like rubber/ EPDM Shore hardness adjustable 13 - 45 Shore A	black / beige	100 : 10	17 – 27	RT	7 – 10	A 13	750	ISO 37	2,2 kN/m with incision		1,1
GM 951-1 A / B			100 : 10	17 – 27	RT	7 – 10	A 45	980	ISO 37	5,5 kN/m with incision		2,0
GM 956 A / GM 956-30 B	high tear strength, easily dyeable, free of mercury, shore hardness (flexibility) adjustable A 30- 80	transparent	100 : 195	20 – 30	70 **	3 – 4	A 30	2000	ISO 37	6,7 kN/m with incision		2,2
GM 956 A / GM 956-80 B		transparent	100 : 80	15 – 20	70 **	2 – 3	A 83	600	ISO 37	15 kN/m with incision		8
GM 956-90 A / B	shore A hardness 90, excellent flow properties, easily dyeable, high tear strength, odourless, free of mercury	transparent	100 : 80	15 – 18	70 **	1 – 2	A 90	280	ISO 37	48 kN/m		7
GM 973 A / B	high Shore A hardness	beige / black	100 : 15	12 – 15	RT	12 – 16	A 90	550	ISO 527	55 kN/m		16

* max. values will be reached after post curing according to the technical data sheets
 ** processing at room temperature possible

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